

Date: Tuesday, 03/06/2008 12:53:00 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|-------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | WEB |
| Job Number : | 39672 | | |
| Estimate Number : | 10498 | | |
| P.O. Number : | | Part Number : | D2739 |
| This Issue : | 03/06/2008 | Drawing Number : | D2739 REV D |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | / / | Drawing Revision : | D |
| Previous Run : | 39491 | Material : | |
| Written By : | | Due Date : | 10/06/2008 |
| Checked & Approved By : | JUL 08.6.03 | Qty: | 4 Um: Each |
| Comment : | Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM Est Rev: E 07-07-28 As per Rev D JLM Verified By: | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|-------------------------|
| 1.0 | D26005108 | Extrusion 'I Beam' thin |
|-----|-----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web

D-29985

Awm 8-6-3

* (4)

| | | |
|-----|-------------|-----------------------|
| 2.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|

**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd end of extrusion and Deburr holes and ends.

5-Dburr

Awm 8-6-3

(4)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

JL 08/06/04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 03/06/2008 12:53:00 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 39672

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AWM

8-6-4



5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



8-6-4

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: SKID TORE CELL

AWM

8-6-4



7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/04

Job Completion



MF 08-06-04

| W/O: | | WORK ORDER CHANGES | | | | | |
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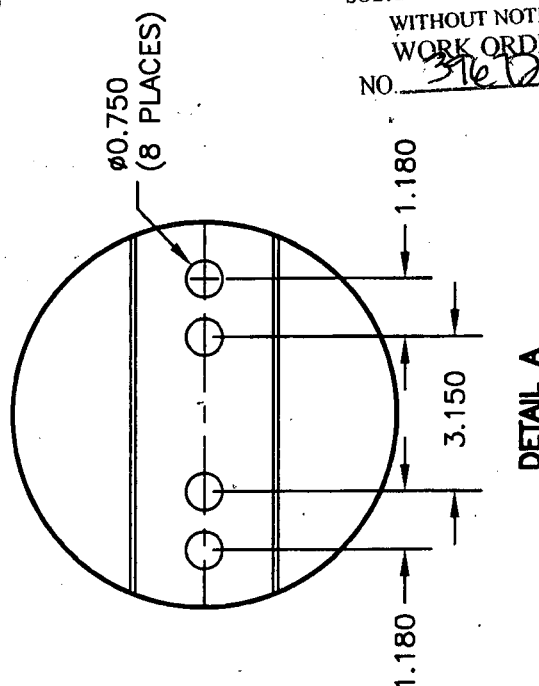
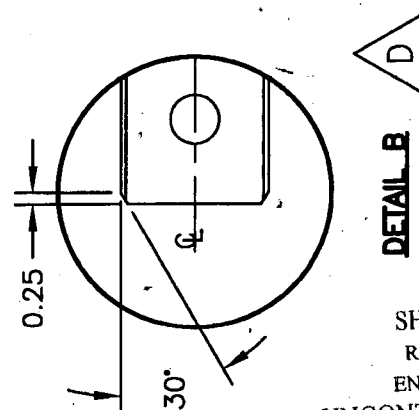
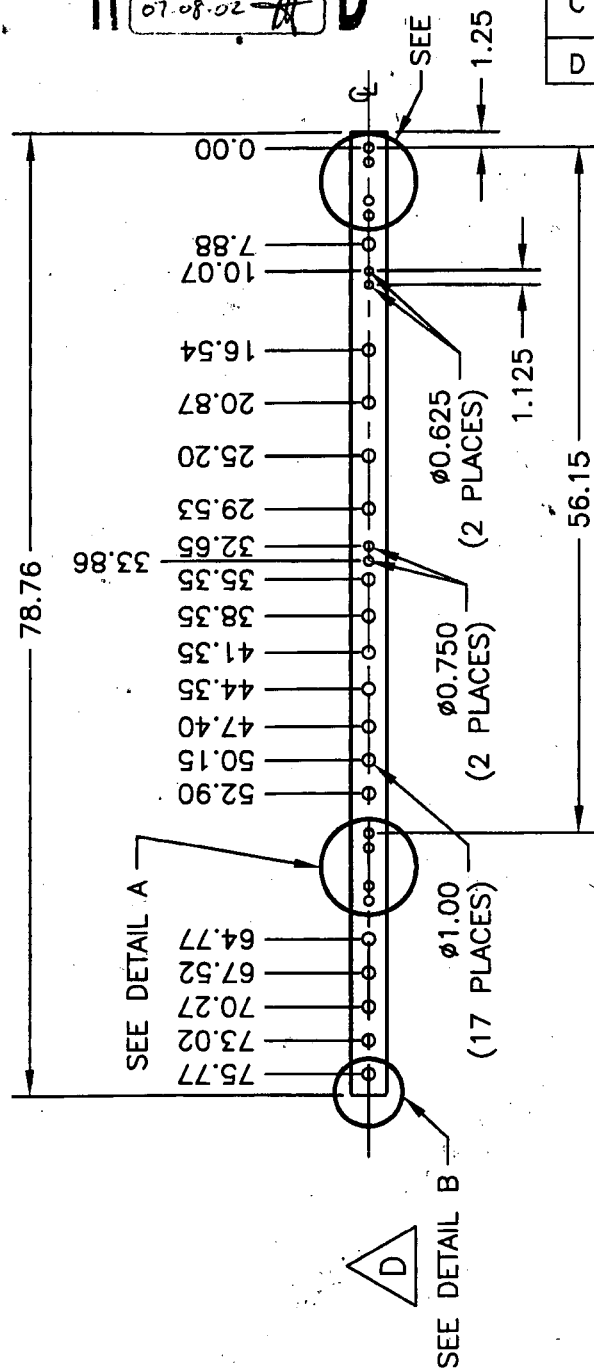
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| | | | | | | | | |

NOTE: Date & initial all entries

RELEASED
07-08-02

| | | | | | |
|------------------|----------|--|--|--|--|
| DESIGN PH | | DRAWN BY CB | | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED PH | | APPROVED [Signature] | | DRAWING NO. D2739 | |
| DATE 07.05.29 | | TITLE WEB | | REV. D SHEET 1 OF 1 SCALE 1:15 | |
| A | 98.04.16 | NEW ISSUE | | | |
| B | 98.11.18 | CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS | | | |
| C | 06.01.05 | ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS | | | |
| D | 07.05.29 | ADD BEVEL TO FWD END; ADD DETAIL B | | | |



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31612

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI Q05 4.1
 - 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 4) TOLERANCES ARE PER DART QSI Q18 UNLESS OTHERWISE NOTED
 - 5) PART IS SYMMETRIC ABOUT C

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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